

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-90 Date Opened: 25 May 17 Title: FabricationAircraft OEM: Multiple Aircraft Model: Multiple Product Type: Beam Pin Product Model: N/A Quantity: 10**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification (Original)  
Time Sheet (R&D)  
Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
DM
N/A
N/A

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

11
N/A
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

N/A
DM
N/A
N/A
N/A

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
69830	3	Forward Beam	JC

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

**Traveller**

Initial or N/A


Note:

Work performed by:

Print: D. MartynSign: [Signature]SCA: AD05Date: 25-May-17

ICC / Dual Inspection performed by:

Print: N/ASign: [Signature]SCA: Date: 

Work Order closed by:

Print: J. ClarkeSign: [Signature]SCA: AD02Date: 25-May-17

Approved Manufacturing Facility 73-04

Form 20.0.03

Rev. Original 23 Sep 2014

[illegible][illegible]

Q2	Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
QTY	QTY	LIST OF MATERIALS - STEEL BEAM					
APPROVALS					DATE		
DRAWN		JAY CLARK		03 APR 2008			
CHECKED		E. BURSON					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:							
DIMENSIONS		ANGLES					
K/RF		±0.010		±1/2°			
K/RF		±0.03					
K/RF		±0.1					
AERO DESIGN LTD.							
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVED, 648 BAY VIEW RD - SUITE 200 - R.E. CALGARY, ALBERTA, CANADA, T2C 6P6 PHONE: 403-242-8977 FAX: 403-242-8958							
BELL 206 / 407							
QUICK RELEASE CARGO BASKET							
FORWARD BEAM FABRICATION							
SCALE 1 : 1		TYP		SHEET NO.		REV	
SHEET 1 OF 1		A0		69830		3	



# Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Stop No. of pieces: 11

Manufacturer: Aero Design Ltd.

Part No.: 69830-21 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-90

Remaining Tasks to be Performed: \_\_\_\_\_

\_\_\_\_\_

Signature: David Marty

Date: May 25/2017 Lic. No. / SCA AD-05

Serviceable



## **Aero Design Ltd.**

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AMF 73-04

**Serviceable**

**Remarks**

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Machine 11 (Stop p# 69830-21)

WO# 2017-90

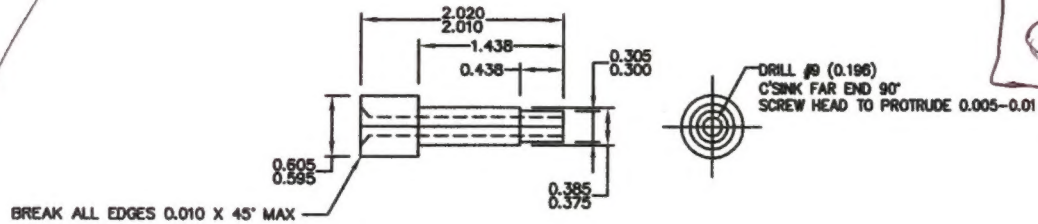
Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

# MATERIAL 6061-T6 ALUMINUM

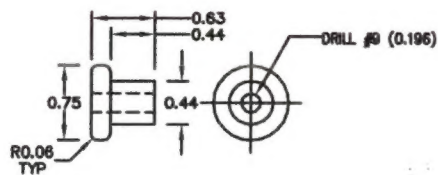
2017-90



69830-21 STOP

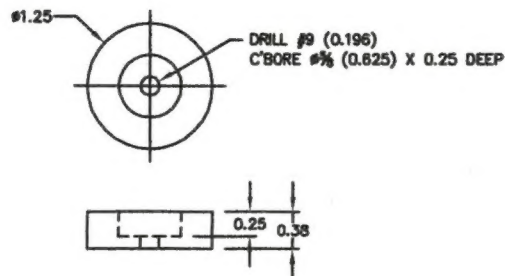
QTY. 11/10

QTY. 200 / 500



69830-22 KNOB

QTY. 200 / 500



69830-08 KNOB

QTY. 50

STOCK SURFACES TO BE BUFFED OR SKIM PASS TO CLEAN UP

## BUSHING/TUBE/GUIDE/THREADED LUG

### General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam  
76630 – Bell 206L/407 High Mounting Beam  
78633 – Airbus AS350 Aft Beam  
78634 – Airbus AS350 Forward Beam  
49215 – Lid Prop Bushing  
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop  
94023 – Airbus AS350 XL Attachment Hoop  
82715 – Airbus AS350 Short Step Assembly  
82733 – Airbus AS350 Short Step Bracket  
36274 – Handle Lever Bushing  
36275 – Handle Support and Bushing

Work Order: 2017-90

Batch Quantity: 10

**Complete**  
(initial or SCA #)

Date Open: 25 MAY 2017

Part Number: 69830-21

AD  
73-04  
05

#### 1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 16043

AD  
73-0  
05

#### 2. Turn stock material:

**CAUTION:** Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

- Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
- Setup stop and face other end to length @ 1000 RPM.
- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.